

In re: Beyerer et al.  
Appl. No. 09/868,716  
Filed: June 20, 2001  
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a computer for processing the data received from the camera.

45. (Amended) A method of detecting defects on shot cores or core packets used in the foundry industry comprising the steps of

C3 illuminating each shot core or core packet by at least two light sources from different directions and so as to produce shadows which magnify an area of the core or core packet,

recording by means of a camera each illuminated shot core or core packet and the magnifying shadows resulting from the illumination to thereby produce recorded data which comprise a recorded image, and

processing the recorded data in a computer and including processing the recorded image by comparing the recorded image with a record of reference data, and

wherein the processing step further includes a brightness adjustment for adapting the gray-scale values of the image.